

SPLIT
(2)

Work Order ID 115957

April-07-14 9:17:38 AM

115957

Page 1

Item ID: D4806-3

Revision ID:

Item Name: Stud

Start Date: 04/04/2014 Start Qty: 1.00 *1*

Required Date: 04/04/2014 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4806	Rev A

190
100
Doosan
Doosan Lathe

DOOSAN LATHE

Memo
1- Turn as per Folio FB276
Rev: NA & Dwg D4806 Rev: A

2- Deburr

0.00

0.00

110
110
QC
Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

14-4-8
DAS
40
9-89
DAS
25
9-89

14/04/07

DAS
25
9-89
14-4-8

[Signature]

240
22
2-58

240
40
284

240
22
284

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Page 2

Item ID: D4806-3

Revision ID:

Item Name: Stud

Start Date: 04/04/2014 Start Qty: 1.00

Required Date: 04/04/2014 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

14/04/08

2

0

DAS
14
9-88

130

Outsource process - NDT per QSI038 4.1

0.00

130

Outsource2

Memo

0.00

Outsource process - NDT

ISSUE P/O: 23701

C OF C IS REQUIRED

CZ 14/04/08 (2)

140

Receive & Inspect for Damage & Mat'l Certs

0.00

140

Packaging

Memo

0.00

Packaging

Pep/s (2)

2002
1-1
2002

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Item ID: D4806-3

Revision ID:

Item Name: Stud

Start Date: 04/04/2014 Start Qty: 1.00 *1*

Required Date: 04/04/2014 Req'd Qty: 1.00 *1*

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

Quality Control

0.00

160

Identify as per dwg & Stock Location: ST123

0.00

160

Packaging

Memo

Packaging

0.00

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

Quality Control

0.00

DAS
33 14-04-09
9-89

ME
14-4-10

Picklist Print

April-07-14 9:17:37 AM

Page 1

Work Order ID: 115957

115957

Parent Item: D4806-3

D4806-3

Parent Item Name: Stud

Start Date: 04/04/2014

Required Date: 04/04/2014

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A NEW ISSUE 14-01-16 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.625		Purchased	No				f	5.5000		1			
M174PH-H900R0 625									**	SL 1448			
17-4 SS H900 ROUND BAR 0.625													

Location

Loc Qty

Loc Code

MAT031

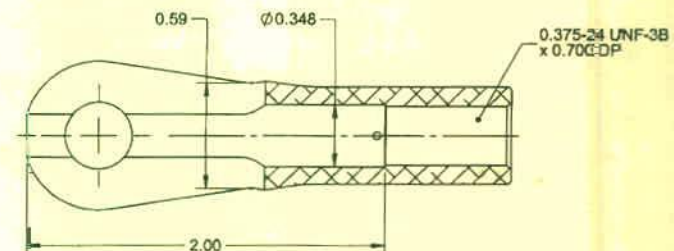
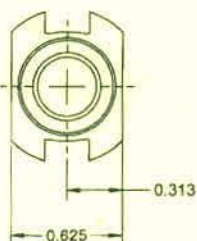
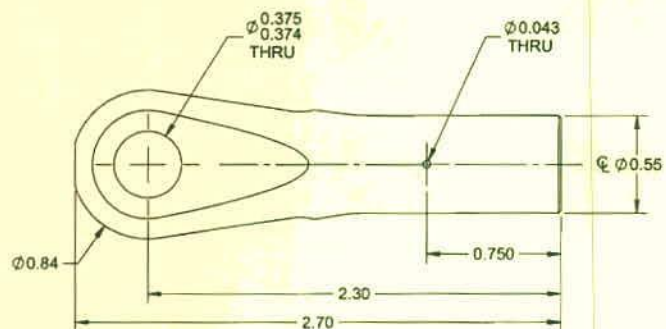
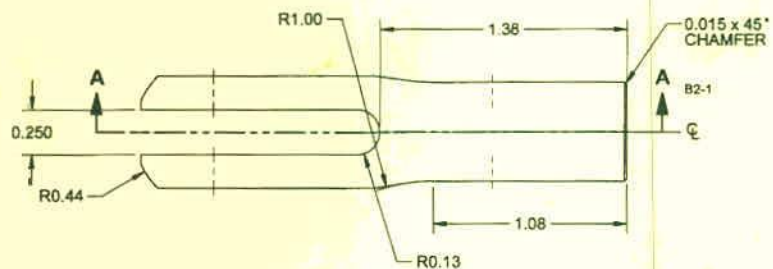
5.5

7

M127334

5.5

55



SECTION A-A D5-1

D4806-1 CLEVIS

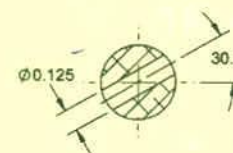
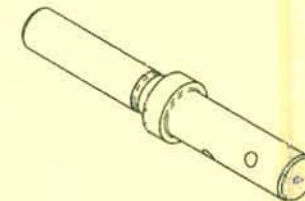
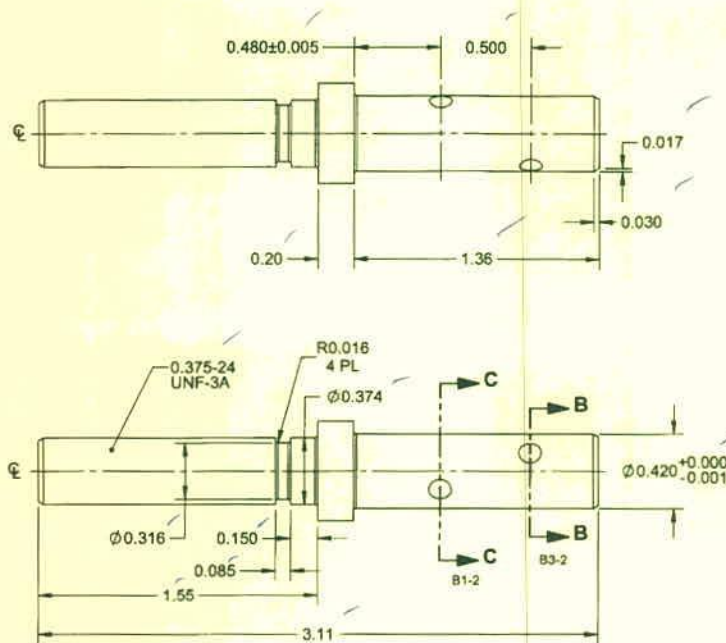
NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.13 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

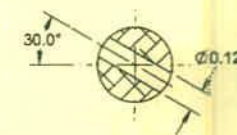
APPROVED

REV.	NEW ISSUE	DESCRIPTION	REV.	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4806 TITLE END FITTING	REV. A	13.02.18
DRAWN	RF		SHEET 1 OF 2	
CHECKED	DC		SCALE	
MFG. APPR.	JLM		NTS	
APPROVED	HS			
DE APPR.	DS			
DATE	13.12.18			

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SECTION B-B C5-2



SECTION C-C C6-2

D4806-3 STUD

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.7
- 7) WEIGHT: 0.11 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4806	REV. A
MFG. APPR.	JLM	TITLE END FITTING	SHEET 2 (OF 2)
APPROVED	HS		SCALE
DE APPR.	DS		NTS
DATE	13.12.18	<small> COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

Jean-Luc Menard

From: Roberto Fuentes
Sent: April-07-14 11:13 AM
To: Jean-Luc Menard; Harvey Siemens
Subject: acceptable to add center drill hole to D4806-3

Hi JL,

Per ours conversation this morning, it is acceptable to add (ref. #3) center drill hole to D4806-3 Stud at end of the thread section.

Roberto

FIRST ARTICLE INSPECTION CHECKLIST

DAS
14
9-89

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

**skyservice****Work Order Traveler**

Sky Service F.B.O. Inc.

Page: 1 of 2

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20484	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 23701
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT INSPECTION (LIQUID PENETRANT) ON 23 MISC PARTS

ITEM ID: E4702-041 LADDER ASSY

1 - WORK ORDER ID#: 111875 (QTY5)

ITEM ID: E4706-041 SUPPORT ASSY

2 - WORK ORDER ID#: 111856 (QTY5)

ITEM ID: D4806-3 STUD

3 - WORK ORDER ID#: 115957 (QTY4)

ID#: D4807-041 SUPPORT ASSY

4 - WORK ORDER ID#: 111664 (QTY3)

ID#: D4882-1 STRUT

5 - WORK ORDER ID#: 115543 (QTY4)

ID#: D4883-1 END FITTING

6 - WORK ORDER ID#: 113533 (QTY4)

Action Taken:	Date:	Initial/Stamp:				
LIQUID PENETRANT INSPECTION CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-6) AS PER ASTM1417M-13	APR 08 2014	<div>DOT APP 177 53-89</div>				
NO CRACK FOUND						
Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018						
Description	Location	P/N	Qty	Batch	S/N Off	S/N On

I certify that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:

Name:

ANTONINO MARCHETTA

Date:

APR 08 2014

